Quality Control

	er ID 106705 3 11:24:40 AM		*106	3705*					Page 1
Item ID:	D3014-1		Accept	*N900	04010	10 *	Setup Sta	rt *N	S1*
Revision ID: Item Name:	Lock Nut	100)				Sto	p *N	S2*
Start Date:	9/11/13 Start Qty: 50.	00 *50*		Cust Item 1	ID:				.)/
Required Date:	: 9/11/13 Req'd Qty: 50.			Customer:					
Reference:						,	Run Sta	rt	
Approvals:	Process Plan:ML5	Date: 13-09-1	2_Tooling:	D	ate:			171	R1*
	QC:	Date:	_ SPC (Y/N):	D	ate:	_	Sto	*N	R2*
Sequence ID/ Work Center I	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan	-	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3014	Rev A								
*100 *100* Purchasing Purchasing	Possible	O:	0.00 0.00 nylon insert) LNSCC14P			<u> </u>	£1310	5416	100
110 *110* Packaging	Memo	or Damage & Mat'l Certs	0.00 0.00		·		13	10/9	(195)
Packaging 120 *120* QC	QC6- Inspect dimen	Material Release Note is attach	0.00 DAS	3110104		0.5P0 4.110	15		

DQA:	Date:	c 🚾
_		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

								•		QA Closed:	Date	:	
Work Orde	ari•				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No.			Rework Scrap Use-as-is		Skid-tube Crosstul Machining Small F. Thermoforming Finishi			-	Water Jet d. Eng. Coor.	Engineering Quality Other			
NCR N	lo				Work Order Update] "		arge Fab	Finishing Composite	Rec/Store/Packaging Other Supplier			
Root				Descri	ption of work order update	Initi	ial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training	,												
Unapproved			İ	<u> </u>	E.	AULT C	ATEG	ORY					
Landir	ng Gear				General				<u>.</u>		.,		
	Bending Centre Not Concentric to O/S BOM/Route Broken/Dama			Bend	Har	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear			Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink				Ма		nance		Part Moved Positioned Wrong				
	Inspectio	n Strip in	Tube	-	Cut Too Short Drill Holes	Mis	sread fset	c u	E	Power Loss/		Other	
	Torque V	Vaves in E		n	Drawing	Ou	it of Ca	alibration				·	
	Turning S Wave/Tw				Finish Folio			equence Dimensions				·	

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	II K				1 1 7 1 7	/ 11.7

106705

Page 2

September-11-13 11:24:40 AM D3014-1 Accept *N900040100* Setup Start Item ID: **Revision ID:** Stop Item Name: Lock Nut 9/11/13 **Start Qty: 50.00 Start Date: Cust Item ID:** Req'd Qty: 50.00 Required Date: 9/11/13 **Customer:** Reference: Run Start Date:_____ **Tooling: Approvals: Process Plan:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Reject Insp. Operation Accept Work Center ID Qty Qty Number Code Description **Run Hours** Identify as per dwg & Stock Location: 4077 0.00 130 *120* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 140 *140* OC 0.00 Memo Quality Control

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCN.	es / NO				WORK ORDER NON-	COI	VI OIN	VIANCE / OF	DAIL	QA Closed:	Date	2:
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	e/Packaging Supplier	Other
Root				Descri	ption of work order update	П	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator		ļ										
Material						Ì						
Setup						1						
Other												
Process						İ						
Supplier												
Training												
Unapproved												
					F	AUI	T CATE	GORY			****	
Landin	g Gear				General		•		_	٦.	_	_
L	Bending			_	Bend		Grain			Ovalized	1	Pressure/Forced
	Centre No	ot Concer	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	L	Inspect	ion Incomplete		Part Incorre	ct _	Weld
	Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			L	Contamination	L	Mainte	enance		Part Moved		
	Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short		Misread	d	<u></u>	Power Loss/	Surge	Other
[Ripples in	Bend			Drill Holes		Offset					
[Torque W	/aves in E	xtrusion	ı [Drawing		Out of	Calibration				
	Turning S	equence			Finish		Out of	Sequence				,
	Wave/Tw	ist in Tub	oe -		Folio		Outside	Dimensions				

- Picklist Print

September-11-13 11:24:39 AM

Page 1,

Work Order ID:

106705

Parent Item:

D3014-1

Parent Item Name:

Lock Nut

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: A01.04.06New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PFS-LNSCC14P		Purchased	No			110	Each	0.0000	1	50			

/13/149 (100)

		↑ **
DQA:	Date:	*

NCR:	Yes /	No No
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WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Date		
Work Order	·•				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Part No	D				Rework Scrap Use-as-is Work Order Update] 	N herm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Quality Rec/Store/Packaging Other			
WCK W	J				Work Order opuate	.		carge rab	Composite		Supplie!		
Root				Descri	ption of work order update	Initi	al	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data										,	-		
equip/Tooling													
Operator										1			
Material													
Setup													
Other						1							
Process							1						
Supplier							İ						
Fraining						1							
Jnapproved			,										
					F	AULT C	ATEC	ORY					
Landing	g Gear				General						_	_	
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced	
L	Centre No	ot Concei	ntric to	o/s	BOM/Route	Har	rdwai	re	L	Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Ins	pecti	on Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped			Burrs	Inst	tructi	ons Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	<u></u> Ма	ainte	nance	L	Part Moved			
	Heat Trea	it			Countersink	Mis	slabe	led	<u>L</u>	Positioned V	Vrong	_	
	Inspection	n Strip in	Tube		Cut Too Short	Mis	sread			Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes	Off	set						
	Torque W	/aves in E	xtrusio	n [Drawing	Out	t of C	alibration					
	Turning S	equence			Finish	∐Ou•	t of S	equence					
	Wave/Twist in Tube			lou	Outside Dimensions								

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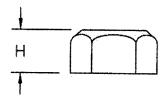




DESIGN (A)	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARK	
CHECKED	APPROVED #	DRAWING NO. D3014	REV. A SHEET 1 OF 1
DATE 01.04.23		TITLE LOCKNUT	SCALE NTS
Α	01.04.23	NEW ISSUE	

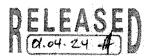
SPECIFICATION CONTROL DRAWING

DESCRIPTION: CRIMPED SS LOCKNUT (NO NYLON INSERT).
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED. ALL DIMENSIONS ARE IN INCHES.



PART NO	SIZE	HEIGHT	POSSIBLE SUPPLIER
		H	
D3014-1	1/4-20 UNC	0.25	ACKLANDS, P/N PFS LNSCC14P
	·		

	-		



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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053 **PURCHASE ORDER**

Purchase Order ID PO21351

Purchase Order Date -9/16/2013

PO Print Date 9/16/2013

Page Number 1 of 2

Order From:

ACKLANDS - GRAINGER INC.

P.O. BOX 2970

WINNIPEG, MB R3C 4B5

CA

VC-ACK001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

FOZZOZIAD

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Ship Acct: 613 632 2739

Delivered

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ CD Taxable	Req Qty/ Unit of	PO Unit Price	Extended Price
	Line Comments Delivery Comments		Promise Date	Measure		
1	AS PER DWG D3014 REV. A B106705	LOCKNUT	9/19/2013 Yes 9/19/2013	100.00 Each	\$0.05	\$5.10
ç				,	Line Total:	\$5.10
2	71400-40	BTA 87012120 BOOT HAZMAX MENS 16"	9/19/2013	1.00	\$106.15	\$106.15
	·		Yes 9/19/2013	Each		
					Line Total:	\$106.15
Deli	iver To: HUGO					1
3	71725-45	ABU AU-72HB40- 40/MK/KD/W25 CADENAS SECURITE	9/19/2013	40.00	\$19.95	\$798.00
		CADEMAS SOCIALE	Yes 9/19/2013	Each		

ACKI GRAI			765 HA	KLANDS - CAMERO WKESBUI 3) 632-273	N ST. RY ON		-
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À	т 0	EXPEDIEZ À	DART AEROSPACE LTI DART AEROSPAC	D ON

PACKING S		
PACKING SLIP#		PAGE PAGE NO
1417 0429109	1	1 of 1

172628 1726280 IDEUR LESPERSON M85 ER DE COMMANDE ORDER SEO.		21351		ps1. HEF. NO.					NO DUCE	INTRAT I	EXP. DIRECTE I	DATE DE LA COMMA	NDE I	DAILDEL	A FACIOR	_	
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M85 ER DE COMMANDE CO ORDER SEO. NORE DE TABLETTE BIN LOCATION		EHMS		NO.DE VERSEMENTS	M.E.P.	DATE DU PREMIER		151		JAPP DE		PLIQUE AU NO.DE F/ APPLY TO INVOICE		RC/	COPIE		T.P.S/G.S
ER DE COMMANDE CO ORIDER SEQ. M DRE DE TABLETTE BIN LOCATION	***			NO. OF PMTS.	M.B.P.	FIRST PAYME	NT DATE	00/00/0000	ng-11	1	CREDIT S'AP T AUTH	APPLY TO INVOICE	NO. 1	B.O./SUB.			
ORDER SEG. M DRE DE TABLETTE BIN LOCATION		NET 3	0 ***				<u>,</u>			,——			, 			т	
BIN LOCATION	ODE DU MAN. MFG CODE	NO	. DE PIECE ITEM NO	D	PRIX DE LISTE S	UGG LIST	QUANTITE QUANTITE COMMANDEE EX		EE EXPEDIEE COMM	UNITE DE MESUF DE COMMANDE ORDER UNIT	PRIX PRICE		EXTE	PRIX ENSIONNE TENDED		P. P. S. T.	l
A				DESCRIPTION	•		QUANTIT ORDEREI	Y QUANTIT D SHIPPEI	B.O. COOR	OF MEASURE	PAR PER	ESC DIS		PRICE	<u> </u>	S. T.	<u> </u>
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HST	# 889	701272	/TVQ# 10196	602903							SOUS TO	TAL/SUB TOTAL			5.10		
PEDITEUR SHIF				стория вонотом рокт энги энгомильт РРО FR	PAYE DATE D	E LIVRAISION REQU	ISE CONNAISS		1	OMON, DXF. 8.0. (275 T.P.S./T.V.H 305 G.S.T.H.S.T.	1		0.66		
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- 1.0 (July 2000)	DERFE.S	SCHERE	RE	CU A/	1 - 1	/									5.76		
03	E 494	PAR (married (married	RE B)	ECEIVED / I//	, N	LLCO		2	_			М	ONTANT TO	TAL TOTAL	AMOUNT		1
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COPIE DU CLIENT CUSTOMER COPY